






Clamping Force Required for Thermoplastics		
Units	Imperial	Metric
Material	Tons/sq Inches	MN/sq m
ABS	2.8	45.0
CA	1.5	25.0
HDPE	1.7	25.0
HIPS	2.6	40.0
LDPE	1.5	25.0
PA 11 & 12	1.8	30.0
PA 6 & 66	4	60.0
PBT	3.5	55.0
PC	4	60.0
PEEK	3	45.0
PES	6	95.0
PET	2.4	35.0
PET (Bottle Grade)	4.2	65.0
PMMA	3	45.0
POM	4	60.0
PP	2	30.0
PPO	2.5	40.0
PPS	2.5	40.0
PS	1.5	25.0
PSU	7	110.0
PVC	2.5	40.0
SAN	2.6	40.0
TPU	2	30.0

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Conversion	Imperial	 Metric (MN/sq m)
Conversion	Imperial	 Metric (kgf/sq cm)
Conversion	1 MegaNewton(MN)	 Newton (N)
Conversion	1 Newton	 kg
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